

Ship July 14

Split 06/07/21

Date: Thursday, 6/29/2006 3:51:18 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STRUT WELDMENT ASSY
 Job Number : 27783
 Estimate Number : 10675
 P.O. Number : N/A Part Number : D3443041
 This Issue : 6/29/2006 S.O. No. : N/A Drawing Number : D3443 REV. B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : B
 Previous Run : 27512 Material : N/A
 Written By : SEE COMMENT BELOW Due Date : 7/12/2006 Qty: 5 Um: Each
 Checked & Approved By : AF 06 06 29
 Comment : EST REV. A 05.11.17 NEW ISSUE EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D34431	Lug
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)		
Pick:		
Qty	Part Number	Description Batch
1	D3443-1	lug B27529 → 2
		B27794 → 3 PD 06-07-19 (5)
2.0	D34435	Tubing
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)		
Pick:		
Qty	Part Number	Description Batch
1	D3443-5	Tubing B27531
		B27796 → 4 PD 06-07-19 (5)
3.0	D34531	Clevis
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)		
Pick:		
Qty	Part Number	Description Batch
1	D3453-1	Clevis B27701 → 1
		PD 06-07-19 (5)
4.0	238805	SS DOWEL PIN 3/4" LONG
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)		
Pick:		
Qty	Part Number	Description Batch
2	238-805	SS DOWEL PIN 3/4" LONG M14030
		PD 06-07-19 (5)

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Seq. #: Machine Or Operation: Description :

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
Weld assembly as per dwg D3443

PD

06-07-19

⑤

6.0 QC5/9 WELD INSPECTION



Comment: WELD INSPECTION

06/07/20

⑤

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING
1-Mask holes as per dwg D3443

2-Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

a.m

06/07/20

⑤

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SRB 06/07/20

①

9.0 63215K32 Spherical Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
Pick:

Qty	Part Number	Description
1	63215K32	Spherical Bearing

Batch

M(1)481

SRB 06/07/20

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble bearing and ball plungers as per dwg D3443 ensure bearing rotates smoothly

SRB 06/07/20

①

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-07-20

①

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: GA

SRB 06/07/20

①



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Seq. #:

Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

U 0608721
06/07/24

Job Completion



U 0608721

